

5/25

Split B

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23257
<b>Description:</b> Plug	<b>Part Number:</b>	D2594-1
<b>Dwg:</b> D2594 Rev. B1	<b>Qty:</b>	300 268
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	AP	05/05/10	300
2	MC	Make as per Dwg D2594-1 and Folio FA262. Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) Batch M116802	ML	05/10/12	300
3	MC	Break all sharp edges 0.010 max.	DL	05/10/25	300
4A	QC2	Inspect dimensions as per drawing D2594	ML	05/10/12	300
4B	QC8	Second check	ML	05/10/24	300
5	FP	Acid etch and alodine as per QSI 005 4.1	FC	05/11/02	300
6	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)	ML	05/11/09	268
7	QC3	Inspect Powder Coat	CL	05/11/09	268
8	FP	Identify and Stock	ML	05/11/09	268
9	AC	Cost / part .95	SUF	05-11-12	268
10	DC	Close W/O .88 Inspect Level 21	Q	05/11/16	268

Rev	Date	Change	Revised By	Approved
A	98.11.27	New Issue	DM	
B	00.11.01	Removed P/O for Powder Coat – in house process	EC	
C	01.07.17	Reformat step 2	SM	
D	02.08.22	Make in Cobra	KJ RF	

RELEASED  
02/08/22 RF

RF  
02/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 05/11/11

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



04.03.24 RF

1870

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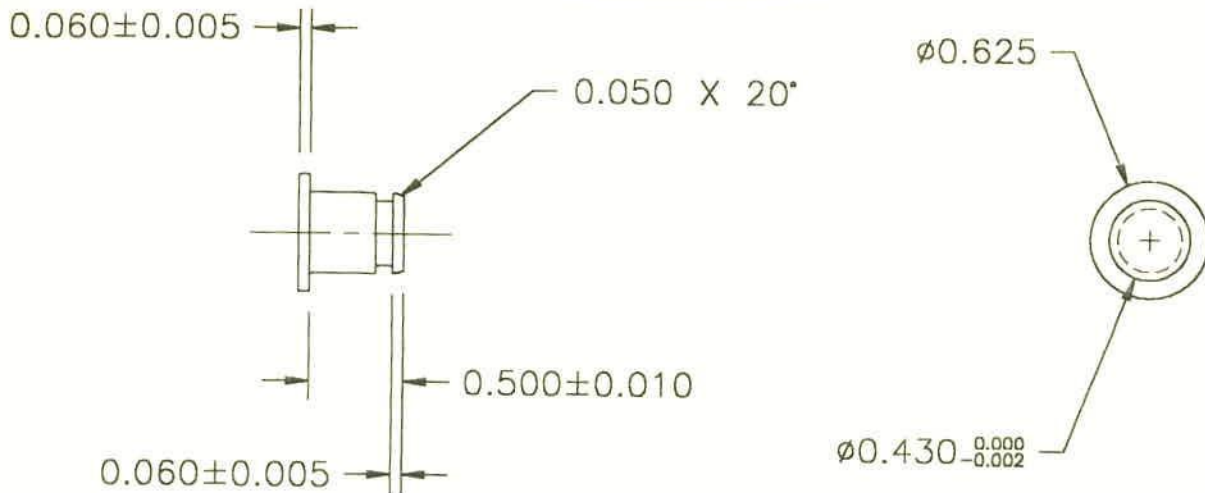
1870



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	<del>RF</del> 02.08.26	ADD POWDER COAT, QSI 018, & QQ-A SPECS.	

D2594-1 PLUG:

RELEASED  
97/03/27 DS



SHOP COPY

RETURN TO  
ENGINEERING

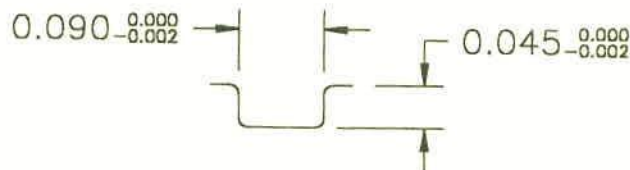
UNCONTROLLED COPY

SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 23251

GROOVE DETAIL (SCALE 5:1)



TOLERANCES ARE PER DMT QSI 018 UNLESS OTHERWISE NOTED

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.5.1) PER QSI COS 4.3

PER QQ-A-225/7 (5052)  
OR QQ-A-225/8 (6061)  
OR QQ-A-225/1 (1100)  
OR QQ-A-200/8 (6061)



D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH  
(PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES: (1) D2594-1 PLUG  
(1) D2594-3 O-RING





# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 10, 2005  
01:31 pm

Work Order No : 0023257  
Project Name : D2594-1  
Project For : WK525  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2594-1  
Description : Plug  
Manufactured : Yes  
Amount Req'd : 300  
Amount Done : 0  
Start Date : 05-10-05  
Est Finish Date : 06-18-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Thursday, 11/10/2005 7:57:43 AM

User: Linda Lacelle

INVENTORY ITEMS PICKED  
FOR SLIP NUMBER 11

Project No. :  
Customer : Dart Helicopters Services  
Part Number : D25941  
Job Number : 23257

Drawing Number : D2594 REV B1  
Drawing Name : PLUG  
Due Date : / /  
Qty : 268  
Slip # : 11

	Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
1.0 M6061T6R0625 6061-T6 Round Bar .625"							
Available 70.17	MAIN			16807		14.66	14.6600 f



1887-1888

1887-1888		1888-1889		1889-1890		1890-1891		1891-1892		1892-1893		1893-1894		1894-1895		1895-1896		1896-1897		1897-1898		1898-1899		1899-1900		1900-1901		1901-1902		1902-1903		1903-1904		1904-1905		1905-1906		1906-1907		1907-1908		1908-1909		1909-1910		1910-1911		1911-1912		1912-1913		1913-1914		1914-1915		1915-1916		1916-1917		1917-1918		1918-1919		1919-1920		1920-1921		1921-1922		1922-1923		1923-1924		1924-1925		1925-1926		1926-1927		1927-1928		1928-1929		1929-1930		1930-1931		1931-1932		1932-1933		1933-1934		1934-1935		1935-1936		1936-1937		1937-1938		1938-1939		1939-1940		1940-1941		1941-1942		1942-1943		1943-1944		1944-1945		1945-1946		1946-1947		1947-1948		1948-1949		1949-1950		1950-1951		1951-1952		1952-1953		1953-1954		1954-1955		1955-1956		1956-1957		1957-1958		1958-1959		1959-1960		1960-1961		1961-1962		1962-1963		1963-1964		1964-1965		1965-1966		1966-1967		1967-1968		1968-1969		1969-1970		1970-1971		1971-1972		1972-1973		1973-1974		1974-1975		1975-1976		1976-1977		1977-1978		1978-1979		1979-1980		1980-1981		1981-1982		1982-1983		1983-1984		1984-1985		1985-1986		1986-1987		1987-1988		1988-1989		1989-1990		1990-1991		1991-1992		1992-1993		1993-1994		1994-1995		1995-1996		1996-1997		1997-1998		1998-1999		1999-2000		2000-2001		2001-2002		2002-2003		2003-2004		2004-2005		2005-2006		2006-2007		2007-2008		2008-2009		2009-2010		2010-2011		2011-2012		2012-2013		2013-2014		2014-2015		2015-2016		2016-2017		2017-2018		2018-2019		2019-2020		2020-2021		2021-2022		2022-2023		2023-2024		2024-2025		2025-2026		2026-2027		2027-2028		2028-2029		2029-2030		2030-2031		2031-2032		2032-2033		2033-2034		2034-2035		2035-2036		2036-2037		2037-2038		2038-2039		2039-2040		2040-2041		2041-2042		2042-2043		2043-2044		2044-2045		2045-2046		2046-2047		2047-2048		2048-2049		2049-2050		2050-2051		2051-2052		2052-2053		2053-2054		2054-2055		2055-2056		2056-2057		2057-2058		2058-2059		2059-2060		2060-2061		2061-2062		2062-2063		2063-2064		2064-2065		2065-2066		2066-2067		2067-2068		2068-2069		2069-2070		2070-2071		2071-2072		2072-2073		2073-2074		2074-2075		2075-2076		2076-2077		2077-2078		2078-2079		2079-2080		2080-2081		2081-2082		2082-2083		2083-2084		2084-2085		2085-2086		2086-2087		2087-2088		2088-2089		2089-2090		2090-2091		2091-2092		2092-2093		2093-2094		2094-2095		2095-2096		2096-2097		2097-2098		2098-2099		2099-2100		2100-2101		2101-2102		2102-2103		2103-2104		2104-2105		2105-2106		2106-2107		2107-2108		2108-2109		2109-2110		2110-2111		2111-2112		2112-2113		2113-2114		2114-2115		2115-2116		2116-2117		2117-2118		2118-2119		2119-2120		2120-2121		2121-2122		2122-2123		2123-2124		2124-2125		2125-2126		2126-2127		2127-2128		2128-2129		2129-2130		2130-2131		2131-2132		2132-2133		2133-2134		2134-2135		2135-2136		2136-2137		2137-2138		2138-2139		2139-2140		2140-2141		2141-2142		2142-2143		2143-2144		2144-2145		2145-2146		2146-2147		2147-2148		2148-2149		2149-2150		2150-2151		2151-2152		2152-2153		2153-2154		2154-2155		2155-2156		2156-2157		2157-2158		2158-2159		2159-2160		2160-2161		2161-2162		2162-2163		2163-2164		2164-2165		2165-2166		2166-2167		2167-2168		2168-2169		2169-2170		2170-2171		2171-2172		2172-2173		2173-2174		2174-2175		2175-2176		2176-2177		2177-2178		2178-2179		2179-2180		2180-2181		2181-2182		2182-2183		2183-2184		2184-2185		2185-2186		2186-2187		2187-2188		2188-2189		2189-2190		2190-2191		2191-2192		2192-2193		2193-2194		2194-2195		2195-2196		2196-2197		2197-2198		2198-2199		2199-2200		2200-2201		2201-2202		2202-2203		2203-2204		2204-2205		2205-2206		2206-2207		2207-2208		2208-2209		2209-2210		2210-2211		2211-2212		2212-2213		2213-2214		2214-2215		2215-2216		2216-2217		2217-2218		2218-2219		2219-2220		2220-2221		2221-2222		2222-2223		2223-2224		2224-2225		2225-2226		2226-2227		2227-2228		2228-2229		2229-2230		2230-2231		2231-2232		2232-2233		2233-2234		2234-2235		2235-2236		2236-2237		2237-2238		2238-2239		2239-2240		2240-2241		2241-2242		2242-2243		2243-2244		2244-2245		2245-2246		2246-2247		2247-2248		2248-2249		2249-2250		2250-2251		2251-2252		2252-2253		2253-2254		2254-2255		2255-2256		2256-2257		2257-2258		2258-2259		2259-2260		2260-2261		2261-2262		2262-2263		2263-2264		2264-2265		2265-2266		2266-2267		2267-2268		2268-2269		2269-2270		2270-2271		2271-2272	
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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
10:27 am

Work Order No : 0023257  
Project Name : D2594-1  
Project For : WK525  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2594-1  
Description : Plug  
Manufactured : Yes  
Amount Req'd : 300  
Amount Done : 32  
Start Date : 05-10-05  
Est Finish Date : 06-18-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
Part/All Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	3.60	100.00	3.60	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	12.32	100.00		
Production Cost :	0.00	223.01	100.00	15.24	207.77
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	8.50	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	226.61	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	226.61			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.65
Profits/(Loss) :	0.00	( -226.61)





Date: Saturday, 11/5/2005 7:46:15 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	PLUG
<b>Job Number</b> :	23257		
<b>Estimate Number</b> :	10178		
<b>P.O. Number</b> :		<b>Part Number</b> :	D25941
<b>This Issue</b> :	11/5/2005	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2594 REV B1
<b>First Issue</b> :	/ /	<b>Project Number</b> :	
<b>Previous Run</b> :		<b>Drawing Revision</b> :	B1
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	11/30/2005
<b>Written By</b> :		<b>Qty:</b>	300
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est D 02.08.22 Make in Cobra KJ		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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**Comment:** Qty.: 0.0547 f(s)/Unit Total : 16.4115 f(s)  
 Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)  
 1100-0 (QQ-A-225/1) Ø0.625" Rod  
 (M5052H32R0.625) or (M6061T6R0.625) Batch \_\_\_\_\_

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



**Comment:** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
 HARDINGE CNC LATHE SMALL  
 1-Make as per Dwg D2594-1 and Folio FA262.  
 2-Break all sharp edges 0.010 max.

3.0	QC6	DIMENSIONAL CHECK
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**Comment:** Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
 DIMENSIONAL CHECK

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
 HAND FINISHING RESOURCE #1  
 Acid etch and alodine as per QSI 005 4.1

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
 HAND FINISHING RESOURCE #1  
 Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)



Date: , Saturday, 11/5/2005 7:46:15 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 23257

Part Number: D25941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

8.0

DC

DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
DOCUMENT CONTROL  
Inspection Level 21

Job Completion





